

# Work Order ID 77729

**\*77729\***

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Monday, December 19, 2011 11:12:53 AM

Item ID: D4202-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacer  
 Start Date: 12/19/2011 Start Qty: 400.00 **\*400\*** Cust Item ID:  
 Required Date: 12/20/2011 Req'd Qty: 400.00 **\*400\*** Customer:  
 Reference: *11.12.19*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4202	<i>C 11.12.19</i>

100	Hardinge CNC LATHE SMALL	0.00							
<b>*100*</b>									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1- Machine as per Folio FB015 FOLIO REV: <i>C</i> DWG REV: <i>C</i>								
	2- Deburr								

*323*

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

*308*  
*323*  
*11.12.19*  
*Re 11.12.20*



# Picklist Print

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Work Order ID: 77729

Parent Item: D4202-1

Parent Item Name: Spacer

Start Date: 12/19/2011

Required Date: 12/20/2011

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD  
04-05 JLM VERIFIED BY:DD

IPP REV:B AS PER REV B 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<del>M6061T6T0.500W.049</del>		Purchased	No			100	f	229.1735	0.35	147.36842			
<del>6061-T6 RD Tube .500 x .049W</del>													

1M6061T6T.500W.49.05B

Location

Loc Qty

Loc Code

MAT014

229.173481

117270

229.173481

*Jan 11.12.19*

117084'

119793

108 FT

119160 2' FT

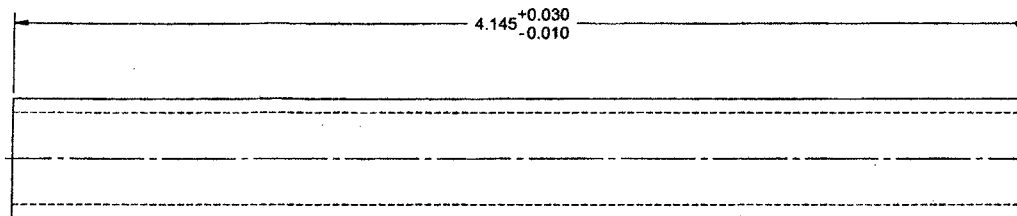
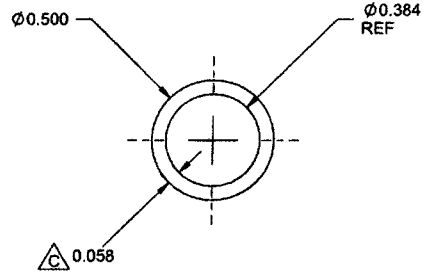
117890 1' FT

12 ft

5 x 12'  
+  
4 x 12'

123' FT





# **D4202-1 SPACER**

*w/077729*

RELEASED  
2011-12-14

- NOTES:**
- 1) MATERIAL: 6061-T4/T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241  
REF DART SPEC M6061T4T0.500W.058  
OR  
6061-T6/T62 ALUMINUM TUBING PER WW-T-700/6, QQ-A-200/8, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241  
REF DART SPEC M6061T6T0.500W.58  
HEAT TREAT TO -T4/-T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.03 lbs

DESIGN	6061-T4 WAS 6061-T6, 0.058 WAS 0.049	CP	11.12.13
DRAWN	0.049 WAS 0.058. REASON: FACILITATE MFG	MB	11.03.22
CHECKED	NEW ISSUE	CP	10.09.22
MFG. APPR.	REV.	DESCRIPTION	BY DATE
APPROVED			
DE APPR.			
DATE	11.12.13		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. C
DRAWING NO.	D4202	SHEET 1 OF 1
TITLE	SPACER	SCALE
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		NTS



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO15697

Purchase Order Date 12/20/11

PO Print Date 12/22/11

Page Number 1 of 1

Order From :

VC-MET004

METCOR INC.  
560 BOUL. ARTHUR SAUVE  
SAINT-EUSTACHE, QC J7R 5A8  
CA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

450 473 1884

Requisition Nbr

Vendor Fax

450 491 5498

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

38112/22

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

REUSED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	77727	D4202-1 SPACER	12/30/11 Yes	123.00	FedEx PI collect	\$4.0000	\$492.00
		Special Inst:	HEAT TREAT TO CONDITION T4 B77727				
2	77729	D4202-1 SPACER	12/30/11 Yes	323.00	FedEx PI collect	\$1.0000	\$323.00
		Special Inst:	HEAT TREAT TO CONDITION T4 B77729				

PO Total: \$815.00

Change Nbr: 2

Change Date: 12/22/11

CZ

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# METCOR INC.

560 BOUL. ARTHUR-SAUVÉ  
ST-EUSTACHE, QC J7R 5A8  
Tel: 450-473-1884 / Fax: 450-491-5498

## Recu de Livraison

Order	Shipper	Shipping Seq.
172350	1	57231

Shipped Complete

**Customer** 215

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

**Shipped To:**

**DART AEROSPACE**  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
Ph: 613-632-5200  
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
PO15697		AL-6061	2011/12/23	PUROLETTER

Quantity	Part No. / Part Name / Part Description	Pounds
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323 D4202-1  
(123) SPACER  
REF.: 77727

11,

(323) D4202-1  
SPACER  
REF.: 77729

CONTENANT: 1 BOÎTE DE CARTON

Container Type	# Of Containers	Container Comments
BOITE DE CARTON	1	

<b>PACKING</b>	
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Quantity Shipped: 323

Pounds Shipped: 11,00

Quantity Remaining: 0

Pounds Remaining: 0,00

Quantity Shipped: 323

Pounds Shipped: 11,00

Signature:

Date:

Shipped ON: 2012/01/06



Metcor Inc.  
560, boul. Arthur-Sauvé  
St-Eustache (Québec) J7R 5A8  
Télécopieur / Fax administration : 450-491-5498  
Télécopieur / Fax production : 450-491-6454

**Certificat de Conformité**  
Certificate of Conformity

BON DE TRAVAIL order	CHARGEMENT load
172350	1

CLIENT / customer: **DC**  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO 15697		AL-8081		

**SPECIFICATIONS DU PROCÉDÉ**  
processing specifications

SDI ANNEAL  
COND.MY

EXIGENCE / requirement: **SPECIFICATIONS / specified** TESTS EXÉCUTÉS / performed: **RÉSULTATS DE TESTS / results**  
Visual

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
323	11	D4202-1 (123) SPACER REF.: 77727  (323) D4202-1 SPACER REF.: 77729  CONTENANT: 1 BOÎTE DE CARTON

**COMMENTAIRES / comments**

INSPECTEUR / Inspector:



DATE: 2012-01-06





560 Boulevard Arthur-Sauvé  
St-Eustache (Québec) J7R 5A8  
Téléphone : 450 473-1884  
Télécopieur production : 450 491-6454

CLIENT / customer 215

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

**Certificat de Conformité**  
Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
172350	1

LIVRÉ À / shipped to:

DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO15697		AL-6061		
<b>SPÉCIFICATIONS DU PROCÉDÉ</b> processing specifications				
SOL ANNEAL COND.W AMS 4081-T4 <i>S. 12/01/11</i>				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
Visual				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
323	11	D4202-1 (123) SPACER REF.: 77727  (323) D4202-1 SPACER REF.: 77729  CONTENANT: 1 BOÎTE DE CARTON		

**COMMENTAIRES / comments**

INSPECTEUR / inspector:

DATE: 2012-01-11